

Work Order ID 109947

December-09-13 7:40:12 AM

109947

Page 1

Item ID: D2940-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 12/09/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/20/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-09 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2940	C
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100

100

HAAS 1
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo
1-Machine as per Folio FA079
2-Debur

0.00

0.00

B.A 13/12/19 08 08 08

20

13-12-22

110

110

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B.A 13/12/19 08 08 08

20

13-12-22

120

120

QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

14-01-08

20

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Packaging

Work Order ID 109947

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Item ID: D2940-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Support

Stop *NS2*

Start Date: 12/09/13 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/20/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180 QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14-01-13

13-01-2014

Picklist Print

December-09-13 7:40:17 AM

Page 1

Work Order ID: 109947

109947

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 12/09/13

Required Date: 1/20/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 02.11.26 Reformat; Added P/OKJ
IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD
IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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DSK081		Manufactured	No			110	Each	5.0000	0.5	11			
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DSK081

D2940-1 Turning Detail

**

B. a 13/12/11

Location

Loc Qty

Loc Code

MAT060

5

101402

1

109063

4

109170

1
4
5

DART AEROSPACE LTD		Work Order:	109947
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	0.250
AB	0.490	0.510		.500	.500	.500	.500	0.500
AC	0.140	0.160		.155	.155	.155	.155	0.145
AD	3.510	3.530		3.511	3.511	3.523	3.523	3.518
AE	1.633	1.673		1.656	1.653	1.655	1.660	1.662
AF	1.493	1.513		1.509	1.504	1.500	1.508	1.507
AG	0.040	0.060		.056	.053	.053	.056	0.052
AH	0.188	0.193		.189	.189	.189	.189	0.188
AI	0.140	0.160		.150	.151	.148	.149	0.145
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		.051	.050	.050	.050	0.050
AL	0.010	0.020		.015	.015	.015	.015	0.015
AM	0.140	0.160		.150	.152	.152	.152	0.143
AN	0.350	0.450		.350	.350	.350	.350	0.350
AO	0.240	0.260		.250	.250	.250	.250	0.250
AP	0.150	0.170		.151	.150	.155	.151	0.155
AQ	0.053	0.073		.063	.063	.063	.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.260	.260	.260	.260	0.261
AT	0.053	0.073		.063	.063	.063	.063	0.063
AU	4.118	4.138		4.129	4.129	4.129	4.129	4.129
AV								
AW								
Accept/Reject								

Measured by: SL **Date:** 13-12-18

Audited by: [Signature] **Date:** 14-01-08

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	[Signature]

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.145	0.145	0.145	0.145	0.145
AD	3.510	3.530		3.515	3.517	3.519	3.523	3.522
AE	1.633	1.673		1.662	1.665	1.663	1.665	1.6635
AF	1.493	1.513		1.508	1.511	1.509	1.507	1.510
AG	0.040	0.060		0.054	0.054	0.054	0.052	0.053
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.145	0.145	0.142	0.151	0.151
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.144	0.143	0.143	0.142	0.143
AN	0.350	0.450		0.350	0.350	0.350	0.350	0.350
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.154	0.155	0.154	0.157	0.154
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.129	4.129	4.129	4.129	4.129
AV								
AW								
Accept/Reject								

Measured by: <i>DA</i>	Date: <i>13/12/19</i>
Audited by: <i>SS</i>	Date: <i>14-01-08</i>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number: D2940-1	
Inspection Dwg: D2940		Rev: C	
		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.145	0.145	0.145	0.145	0.145
AD	3.510	3.530		3.517	3.523	3.524	3.523	3.525
AE	1.633	1.673		1.665	1.662	1.662	1.662	1.661
AF	1.493	1.513		1.510	1.508	1.506	1.506	1.505
AG	0.040	0.060		0.052	0.053	0.051	0.054	0.054
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.144	0.150	0.151	0.151	0.150
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AM	0.140	0.160		0.148	0.150	0.148	0.148	0.148
AN	0.350	0.450		0.350	0.350	0.350	0.350	0.350
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.155	0.154	0.156	0.154	0.156
AQ	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AT	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AU	4.118	4.138		4.129	4.129	4.129	4.129	4.129
AV								
AW								
Accept/Reject								

Measured by: <i>R. A. / J. L.</i>	<i>DAG</i> <i>08</i> <i>2-89</i>	Date: <i>13/12/20</i>
Audited by: <i>[Signature]</i>		Date: <i>14-01-08</i>
Prototype Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#16	#17	#18	#19	#20
HAAS Section								
AA	0.240	0.260		-250	-250	-250	-250	-250
AB	0.490	0.510		-500	-500	-500	-500	-500
AC	0.140	0.160		-145	-145	-145	-145	-145
AD	3.510	3.530		3.525	3.525	3.525	3.529	3.530
AE	1.633	1.673		1.662	1.659	1.660	1.664	1.664
AF	1.493	1.513		1.506	1.505	1.504	1.506	1.505
AG	0.040	0.060		-053	-053	-053	-050	-050
AH	0.188	0.193		-188	-188	-188	-188	-188
AI	0.140	0.160		-150	-149	-148	-148	-148
AJ	2.518	2.538		2.530	2.530	2.530	2.530	2.530
AK	0.040	0.060		-050	-050	-050	-050	-050
AL	0.010	0.020		-015	-015	-015	-015	-015
AM	0.140	0.160		-148	-146	-146	-147	-146
AN	0.350	0.450		-350	-350	-350	-350	-350
AO	0.240	0.260		-250	-250	-250	-250	-250
AP	0.150	0.170		-157	-154	-156	-159	-160
AQ	0.053	0.073		-063	-063	-063	-063	-063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		-261	-261	-261	-261	-261
AT	0.053	0.073		-063	-063	-063	-063	-063
AU	4.118	4.138		4.129	4.129	4.129	4.129	4.129
AV								
AW								
Accept/Reject								

Measured by: SL **Date:** 13-12-21

Audited by: SL **Date:** 14-01-08

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	<u>SL</u>